






Work Order ID **56726**









Page 1

March 5, 2010 9:59:52 AM


Item ID: D3391-011 Accept  Setup Start 
 Revision ID: Stop 
 Item Name: Fwd Tube Assembly
 Start Date: 05/03/2010 Start Qty: 1.00  Cust Item ID:
 Required Date: 17/03/2010 Req'd Qty: 1.00  Customer:

Reference:

Approvals: Process Plan:  Date: 10-3-05 Tooling: Date:
 QC: Date: SPC (Y/N): Date:
 Run Start 
 Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3391	Rev H								
100		0.00							
	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	Cut extrusion to 46.52 +0.010 -0.020								
110		0.00							
	BENDING MACHINE - SKIDTUBES								
CNC Bend 1	Memo	0.00							
CNC Delta 100 Bender	Bend as per Dwg D3391								
120		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

1 11/12/3/19

 10-3-10

h = 6.625"

L = 12.7"

8.10/10



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3391-011

Accept



Setup Start



Revision ID:

Item Name: Fwd Tube Assembly

Stop



Start Date: 05/03/2010 Start Qty: 1.00



Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00				1	0		
HAAS CNC vertical machine #1	1-Machine as per Folio FA590 Rev. AA & Dwg D3391 Rev. H								
	Identify as D3391-1								
	2-Deburr								
140		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00				1	0		
Quality Control									
150		0.00							
	CONVENTIONAL MILLING MACHINE								
Mill Conv	Memo	0.00				1	0		
Conventional Milling Machine	1-Drill .1875" at end of tube as per Dwg D3391								

W/O:		WORK ORDER CHANGES						
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Revision ID:

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

cmk 10/03/28

Quality Control

1 15

170

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

JL 10/03/30

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Drill and c'sink float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size)
(DRILL ALL HOLES)

2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step

3-Open tow cap holes to .208" as per Dwg D3391

4-Open Tow Ring hole to .640" as per Dwg D3391

5- open float bag holes 0.328" and counter sink as per dwg D3391

6-Deburr and scribe batch # inside aft end

7- transfer drill D3391-011 with D3391-013

H 10/3/31

190



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Sulaylos

④

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Start Date: 05/03/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 17/03/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo:

0.00

Hand Finishing

* Parts were left in Acid bath Due to Fine rust
Approx 45mins

M 12/4/11

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

S 10/4/05

(+1)

220

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Install crossbolt spacers per dwg D3391
A/R Magnabond 6398 batch: M 112417

M 10/4/16

2- Grind flush

EXP 11/1/30

3- back drill crossbolt if necessary

M 10/4/17

W/O:		WORK ORDER CHANGES						
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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

240

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

M114841

Memo

0.00

Powder Coating

START TIME: 3:45
OVEN TEMPERATURE: 320°
FINISH TIME: 4:15

RE ALIGNED

1 Bl 10-7-13. Pro →

① 1 Bl 10-7-13.

250

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

=) M 10/07/19

1 Ø

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10-7-13		ADD THAT SEQUENCE PERMANENTLY BE ALLOWED.	BA	10-7-13	1		C 10/10/13	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 56726

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Item ID: D3391-011

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Setup Start



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Start Date: 05/03/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 17/03/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

260



Packaging

Packaging

Identify as per dwg & Stock Location:

used on w/o 56717

Memo

D412-742-641

0.00

0.00

=> M 10/07/20

XL

Ø

270



Skid tubes

Skid tubes

Skid tubes

Memo

**** install D3591-1 spacer as per DSI9364 ****

0.00

0.00

=> M 10/07/19

XL

Ø

280



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

MF 10-7-20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

March 5, 2010 9:59:50 AM

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Work Order ID: 56726



Parent Item: D3391-011



Parent Item Name: Fwd Tube Assembly

Start Date: 05/03/2010

Required Date: 17/03/2010

Comments: IPP A 05.09.13 New issue KJ/JLM
IPP B 06.02.09 Dwg rev.D EC
IPP C 07.03.13 revF dwg ec
IPP D 07.11.01 ecn1053P EC

Start Qty: 1.00

Required Qty: 1.00

D6013-047



Skidtube Material

Manufactured No

220

Each

47.0000

1.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

47

23935

3

26547

44

M 10/3/9

March 5, 2010 9:59:50 AM

Shop Packet Print

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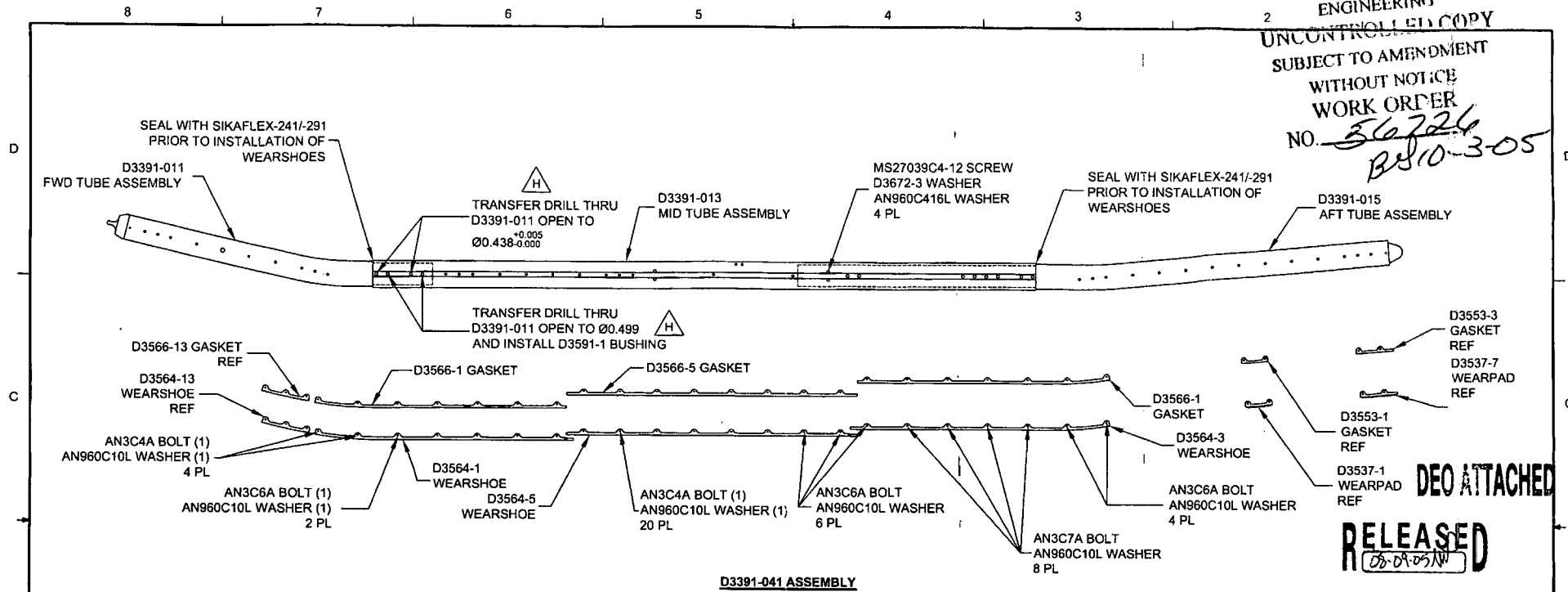
13391-011

Status	Item ID	Rev	Name	Start Date	Quantity	Pe	UOM	Scrap %	Route Seq	IL	Sort	Comments	Date Last Mod	Add Date
✓	D6013-047		Skidtube Material	05/12/2009	1.0000		Each	0 %	100		1		05/12/2009 7:18 PM	05/12/2...
✓	D3401-041	B50316	Tow Cap Assembly	07/04/2010	1.0000		Each	0 %	255		2	X1	1350316	07/04/2...
✓	D3564-13	B57922	Wearshoe	07/04/2010	1.0000		Each	0 %	255		3	X1	1357922	07/04/2...
✓	D3566-13	B53461	Gasket	07/04/2010	1.0000		Each	0 %	255		4	X1	1353461	07/04/2...
✓	D3670-4-200		SPACER	07/04/2010	9.0000		Each	0 %	220		5		058201	07/04/2...
✓	D3672-1	B51671	Phenolic Washer	07/04/2010	4.0000		Each	0 %	255		6	X4	10107119	07/04/2...
✓	AN3C4A	M114859	BOLT	07/04/2010	10.0000		Each	0 %	255		7	X10	10107119	07/04/2...
✓	AN960C10L	M115000	washer	07/04/2010	10.0000		Each	0 %	255		8	X10	10107119	07/04/2...
✓	AELS-1032-130	M114723	INSERT	07/04/2010	2.0000		Each	0 %	255		9	X2	10107119	07/04/2...
✓	AELS-1032-225	M110768	INSERT	07/04/2010	10.0000		Each	0 %	255		10	X10	10107119	07/04/2...

perm change 10.04.07

NAS1149C0332R

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *56726*
BS10-305



D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
4	D3672-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

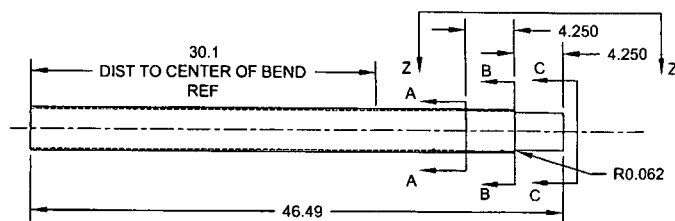
GENERAL NOTES

- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C-BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

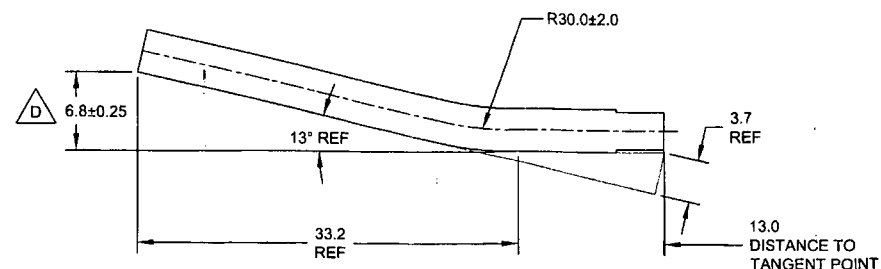
H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE OR COMMERCIALIZED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

DEO ATTACHED

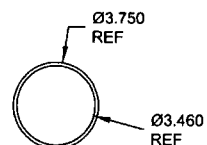
RELEASED
08-09-05



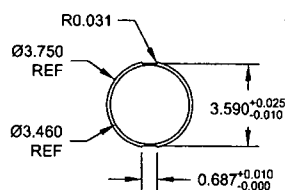
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



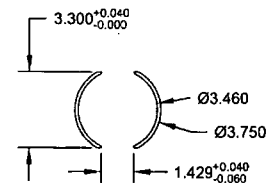
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



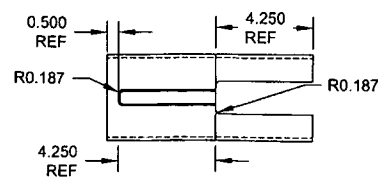
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X

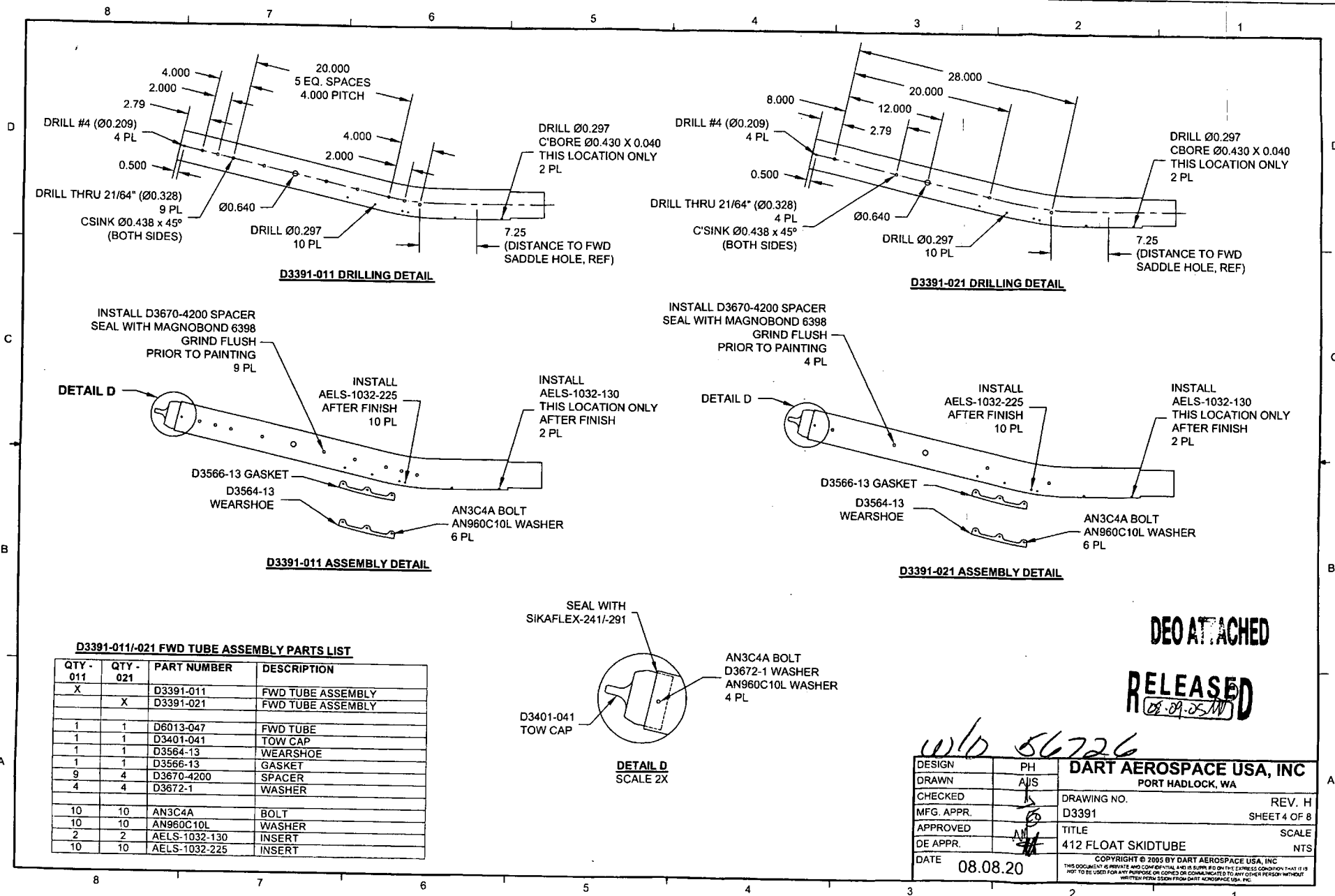


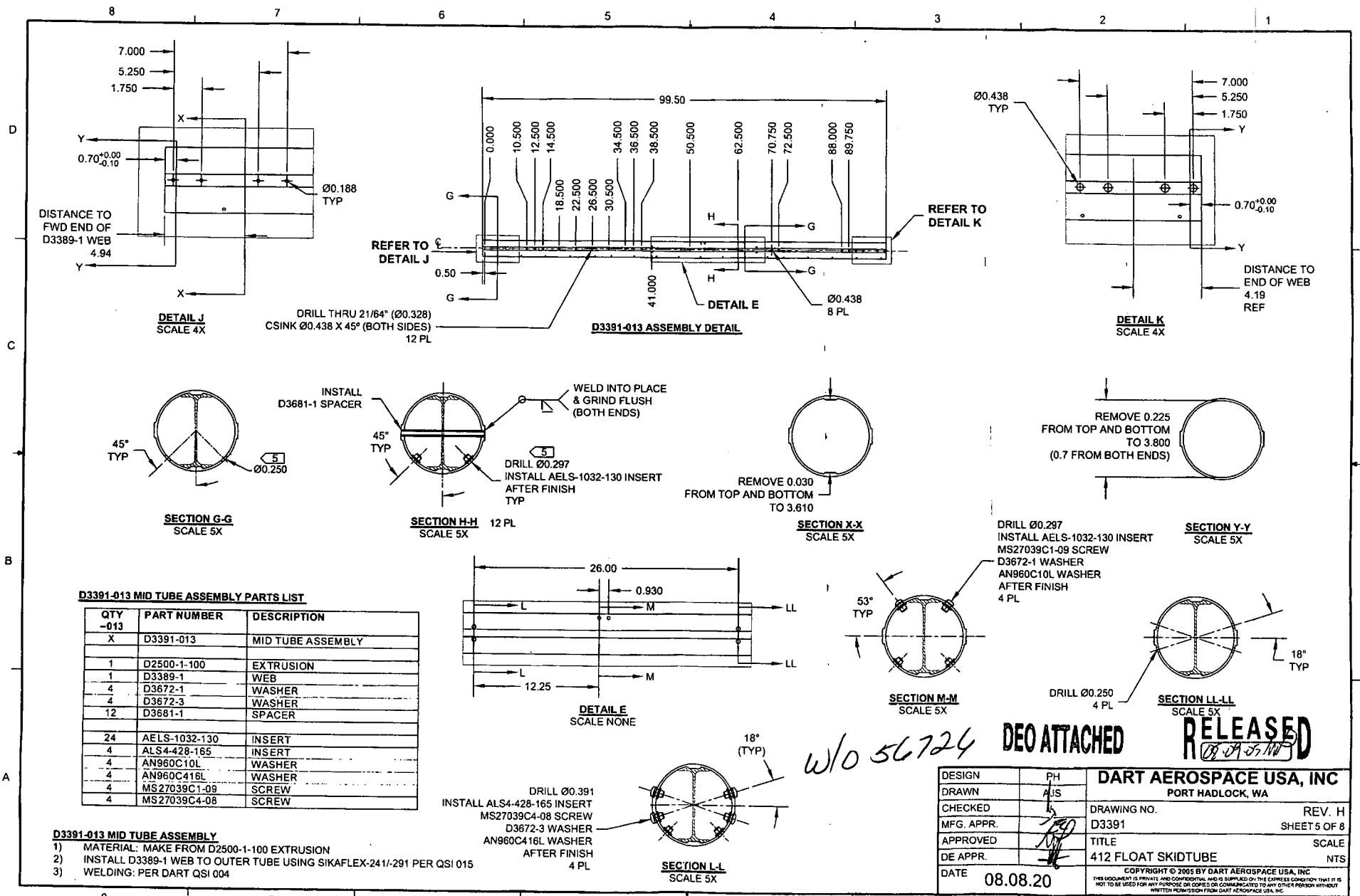
VIEW Z-Z
SCALE 2X

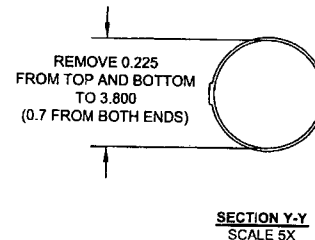
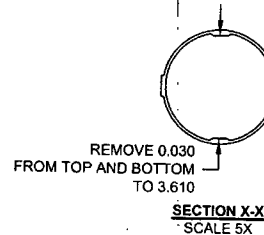
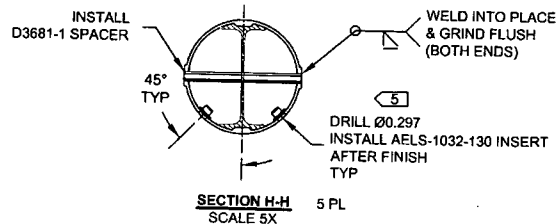
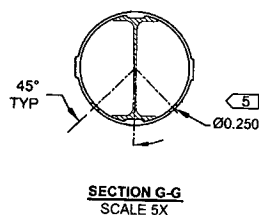
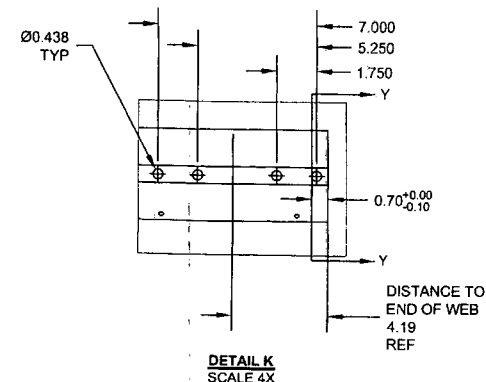
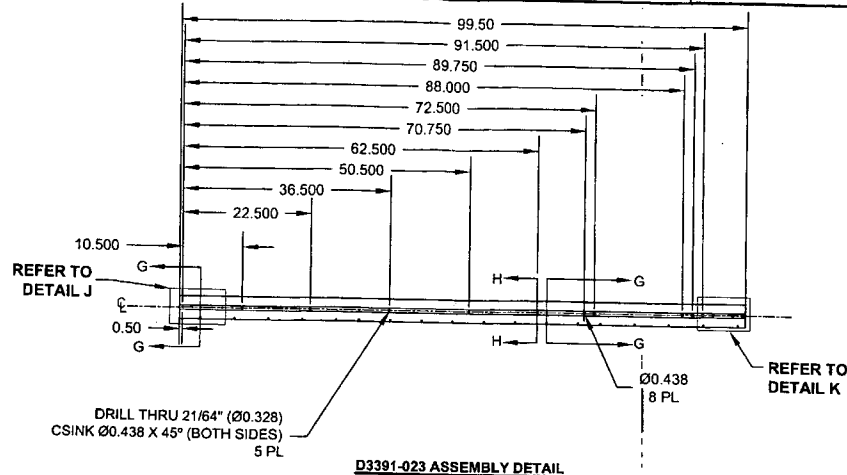
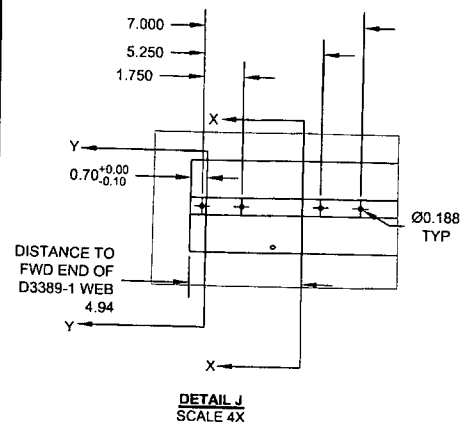
DEO ATTACHED
RELEASED
28-05-77

W/O 56726

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2003 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIES OR COMMERCIALIZED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC	







D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

DART AEROSPACE USA, INC
PORT HADLOCK, WA

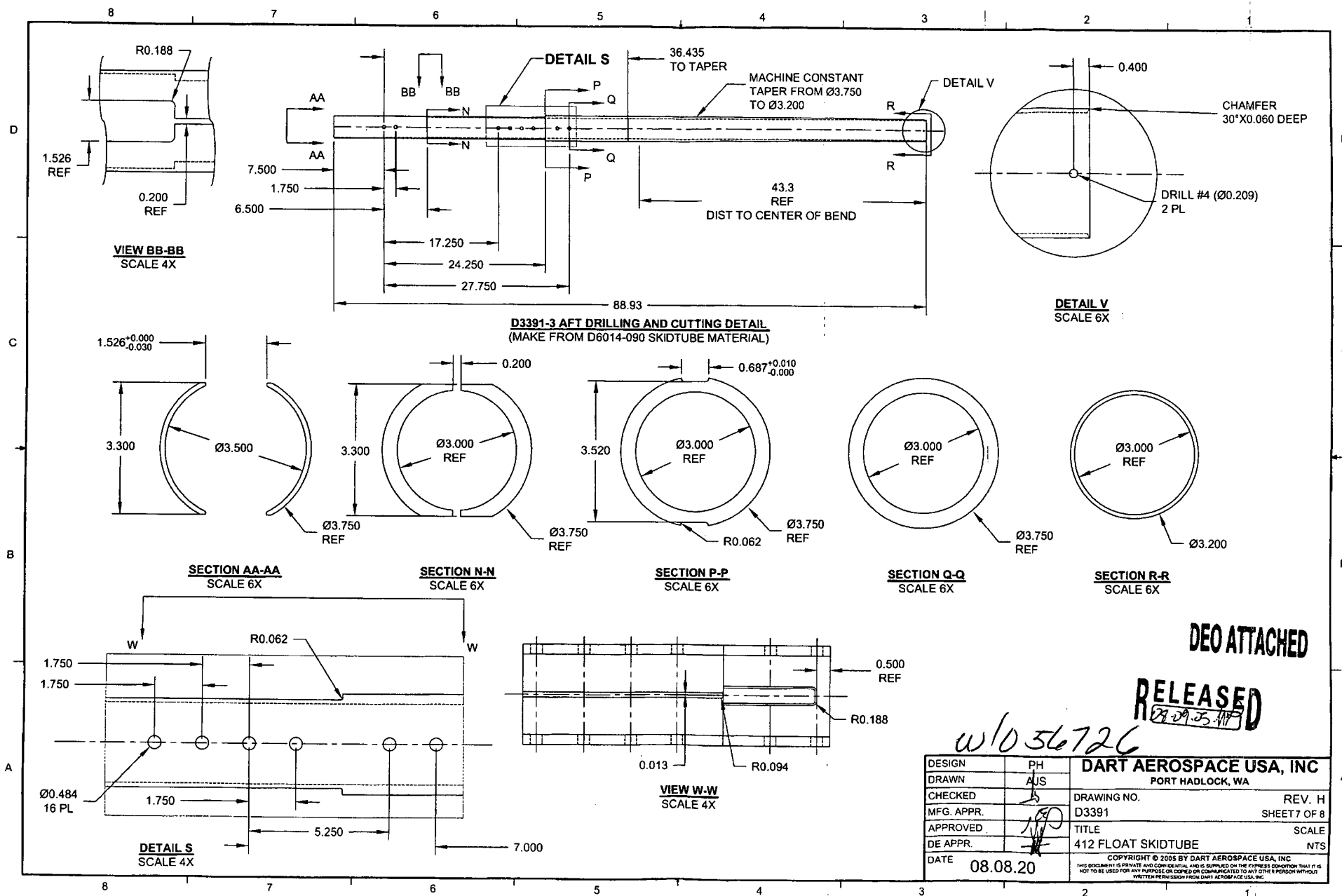
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08-05-10

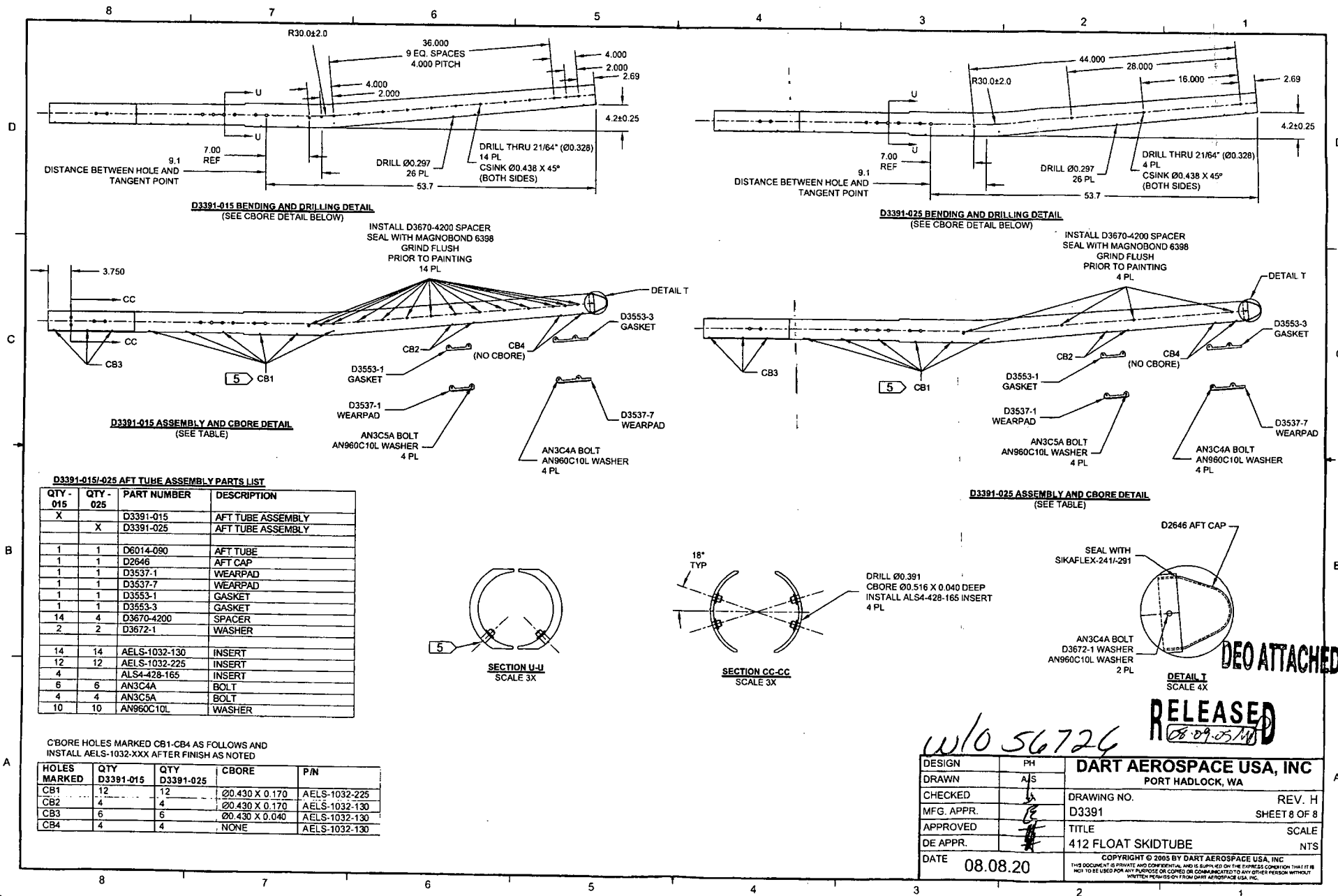
DESIGN PH
DRAWN AJS
CHECKED [Signature]
MFG. APPR. [Signature]
APPROVED [Signature]
DE APPR. [Signature]

DATE 08.08.20

DESIGN NO. D3391
TITLE 412 FLOAT SKIDTUBE
REV. H
SHEET 6 OF 8
SCALE NTS

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DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>h</i>	MFG. APPR. <i>M</i>	APPROVED <i>MP</i>		DE APPR. <i>h</i>		
DATE 09.09.23	DATE <i>06.09.24</i>	DATE <i>09/09/25</i>	DATE <i>09/09/30</i>		DATE <i>09/09/30</i>		

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH~~
~~AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH~~
 LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
 OFF POWDER COATING WITH MEK DEGREASER.

RELEASED
 2010-02-02

MP

w/056726

